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मानक

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Jawaharlal Nehru

“Step Out From the Old to the New”

IS 858 (1981): Handloom Cotton Table Cloth and Napkins [TXD
8: Handloom and Khadi]



“ज्ञान से एक नये भारत का निर्माण”

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“ज्ञान एक ऐसा खजाना है जो कभी चुराया नहीं जा सकता है”

Bhartrhari—Nitiśatakam

“Knowledge is such a treasure which cannot be stolen”

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IS : 858 - 1981

Indian Standard
**SPECIFICATION FOR
HANDLOOM COTTON TABLE CLOTH
AND NAPKINS**
(First Revision)

UDC 645·481·1+642·713 : 677·21·064



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MANAK BHAVAN, 9 BAHADUR SHAH ZAFAR MARG
NEW DELHI 110002

December 1981

AMENDMENT NO. 1 APRIL 1990
TO
IS : 858 - 1981 SPECIFICATION FOR HANDLOOM
COTTON TABLE CLOTH AND NAPKINS
(First Revision)

[Page 6, Table 2, col 4, Sl No. (ii)] — Substitute 'IS : 2977-1964§' for 'IS : 9-1968§'.

(Page 6, Table 2, foot-note marked with ' § ' mark) — Substitute the following for the existing foot-note:

'§Method for determination of dimensional changes of woven fabrics (other than wool) on soaking in water.'

(TDC 13)

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Indian Standard

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(TDC 13)

Indian Standard
**SPECIFICATION FOR
HANDLOOM COTTON TABLE CLOTH
AND NAPKINS**
(First Revision)

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Indian Standard
SPECIFICATION FOR
HANDLOOM COTTON TABLE CLOTH
AND NAPKINS
(*First Revision*)

0. F O R E W O R D

0.1 This Indian Standard (First Revision) was adopted by the Indian Standards Institution on 9 November 1981, after the draft finalized by the Handloom and Khadi Sectional Committee had been approved by the Textile Division Council.

0.2 This standard, which was first published in 1956, has been taken up for revision, in order to make it up-to-date. Important changes carried out in the standard are:

- a) deletion of breaking strength values, since the standard recommends the use of yarn conforming to IS : 171-1973*; and
- b) inclusion of inspection, marking and packing clauses.

0.3 In this revision, the requirements of napkins covered in IS : 857-1956† have also been covered.

0.4 Standards of Weights and Measures Act, 1976 stipulates the use of International System of Units in the country; in order to familiarize the industry with this system, the recommended SI units for use in the textile industry are given in Appendix A.

0.5 For the purpose of deciding whether a particular requirement of this standard is complied with, the final value, observed or calculated, expressing the result of a test, shall be rounded off in accordance with IS : 2-1960‡. The number of significant places retained in the rounded off value should be the same as that of the specified value in this standard.

*Specification for grey cotton yarn (*second revision*).

†Specification for handloom cotton napkins, bleached, striped, checked or dyed.

‡Rules for rounding off numerical values (*revised*).

IS : 858 - 1981

1. SCOPE

1.1 This standard prescribes the constructional particulars and other requirements of four varieties of handloom cotton table cloth and napkins, bleached, striped, check or dyed.

1.2 This standard does not specify the general appearance, feel, finish, shade, etc, of the cloth (*see also 3.3*).

2. MANUFACTURE

2.1 Yarn — The cotton yarn used in the manufacture of table cloth and napkins shall be satisfactory in evenness and reasonably free from neps and spinning defects. The yarn shall conform to Grade 'C' of IS : 171-1973*.

2.2 Cloth — The cloth shall be free from dressing and filling materials and from substances liable to cause subsequent tendering.

2.3 Each transverse end of the table cloth shall be hemmed to a depth of not less than 13 mm, the raw edges having a turn-in of 10 mm before the hem is formed. In the case of napkins, each cut end shall be hemmed to a depth of not less than 10 mm, the raw edges having a turn-in of 5 mm before the hem is formed.

2.3.1 Cotton sewing thread of 60s/6 (100 dtex \times 6) count conforming to IS : 1720-1978† shall be used and the number of stitches shall be not less than 4 per centimetre.

2.4 The table cloth or napkins may have fringes instead of hemming. The length of the fringe, with or without knot, shall be 35 mm, *Min.*

3. REQUIREMENTS

3.1 The constructional particulars of table cloth and napkins shall conform to those given in Table 1.

3.2 The dimensions of table cloth and napkins shall be as agreed to. The dimensions shall exclude fringes, if any. The common dimensions of table cloth and napkins are given below:

*Specification for grey cotton yarn (*second revision*).

†Specification for cotton sewing threads (*second revision*).

<i>Table Cloth</i>		<i>Napkins</i>	
Length × Width		Length × Width	
cm	cm	cm	cm
90	× 90	40	× 40
115	× 115	45	× 45
137	× 137	50	× 50
150	× 150	60	× 60
215	× 170		
365	× 170		

**TABLE 1 CONSTRUCTIONAL PARTICULARS OF HANDLOOM COTTON
TABLE CLOTH AND NAPKINS**

(Clause 3.1)

VARIETY No.	COUNT OF YARN (<i>see NOTE</i>) [COTTON COUNT (UNIVERSAL COUNT)]		ENDS/ cm	PICKS/ cm	WEAVE
	Warp	West			
(1)	(2)	(3)	(4)	(5)	(6)
1	20s/2 (30 tex × 2)	20s/2 (30 tex × 2)	16	16	Plain, matt, honeycomb or huckaback
2	30s/2 (20 tex × 2)	30s/2 (20 tex × 2)	19	19	
3	40s/2 (15 tex × 2)	40s/2 (15 tex × 2)	24	24	
4	40s/2 (15 tex × 2)	30s/2 (20 tex × 2)	26	22	Damask
Tolerance, percent	—	—	±5	±5	—
Method of test	—	—	IS : 1963-1981*		Visual

NOTE — Count of yarn is given for guidance only.

*Methods for determination of threads per unit length in woven fabrics (*second revision*).

3.2.1 A tolerance of ± 2 percent shall be permitted on length and width of the table cloth and napkins subject to a minimum of ± 1 cm, when determined by the method given in IS : 1954-1969*.

3.3 The colour fastness ratings and other requirements of the table cloth and napkins shall conform to those given in Table 2.

TABLE 2 REQUIREMENTS OF HANDLOOM COTTON TABLE CLOTH AND NAPKINS

SL No.	CHARACTERISTIC	REQUIREMENT	METHOD OF TEST
(1)	(2)	(3)	(4)
i)	Colour fastness to:		
	a) Light	4 or better	} See Note IS : 2454-1967* IS : 765-1979† IS : 762-1956‡
	b) Washing: Test 4	3 or better	
	c) Bleaching	4 or better	
ii)	Dimensional change, percent, <i>Max</i>	4	IS : 9-1963§
iii)	Scouring loss, percent, <i>Max</i>	2.5	IS : 1383-1977 (Mild Method)

NOTE — The rating specified is in accordance with IS : 6906-1973¶, which is the basic document on colour fastness ratings to various agencies.

*Method for determination of colour fastness of textile materials to artificial light (xenon lamp).

†Method for determination of colour fastness of textile materials to washing: Test 4 (*second revision*).

‡Method for determination of colour fastness of textile materials to hypochlorite bleaching.

§Method for determination of dimensional changes of cotton and linen woven fabrics on washing near the boiling point (*revised*).

||Methods for determination of scouring loss in grey and finished cotton textile materials (*first revision*).

¶Requirements for colour fastness of handloom cotton textiles.

3.4 If in order to illustrate or specify the indeterminable characteristics, such as general appearance, lustre, feel and shade of the napkins, a sample has been agreed upon and sealed, the supply shall be in conformity with the sample in such respects.

*Methods for determination of length and width of fabrics (*first revision*).

3.4.1 The custody of the sealed sample shall be a matter of prior agreement between the buyer and the seller.

4. INSPECTION

4.1 The table cloth and napkins when visually inspected shall be reasonably free from the following defects:

- a) More than two adjacent ends running parallel, broken or missing and extending beyond 20 cm;
- b) Weft crack or more than two missing picks across the width of the material;
- c) Prominently noticeable weft bar due to the unevenness in raw material, count twist, lustre, etc;
- d) Noticeable selvedge defects;
- e) Noticeable warp or weft float in the body;
- f) Noticeable oil or other stains;
- g) Noticeable hole, cut or tear of up to 3 mm size;
- h) Smash rupturing the texture of the fabric;
- j) Undressed snarle noticeable throughout the piece;
- k) Conspicuous gout due to foreign matter, usually lint or waste woven into cloth;
- m) Absence of heading (where heading is required) or defective heading;
- n) Conspicuous broken pattern;
- p) Defective hemming extending over 2 cm in length; and
- q) Any other flaw which would mar the appearance or affect the serviceability and/or durability of the cloth.

4.1.1 A reference may be made to IS : 4125-1967* for details of these defects.

5. MARKING

5.1 The table cloth and napkins shall be suitably marked or labelled with the following information:

- a) Name of the material and variety number;
- b) Manufacturer's name, initials or trade-mark;
- c) Length and width of the napkins; and
- d) Count of warp and weft yarn.

*Glossary of terms pertaining to defects in fabrics.

5.1.1 The table cloth and napkins may also be marked with the ISI Certification Mark.

NOTE — The use of the ISI Certification Mark is governed by the provisions of the Indian Standards Institution (Certification Marks) Act and the Rules and Regulations made thereunder. The ISI Mark on products covered by an Indian Standard conveys the assurance that they have been produced to comply with the requirements of that standard under a well-defined system of inspection, testing and quality control which is devised and supervised by ISI and operated by the producer. ISI marked products are also continuously checked by ISI for conformity to that standard as a further safeguard. Details of conditions under which a licence for the use of the ISI Certification Mark may be granted to manufacturers or processors, may be obtained from the Indian Standards Institution

6. PACKING

6.1 Unless otherwise agreed upon by the buyer and the seller, table cloth and napkins shall preferably be packed in bales or cases in conformity with the procedure laid down in IS : 1347-1972* or IS : 293-1980†.

7. SAMPLING

7.1 Lot — The quantity of cotton table cloth or napkins of the same variety and dimensions delivered to a buyer at a time shall constitute a lot.

7.2 To ascertain the conformity of the lot to the requirements of this standard, sample shall be drawn and inspected from each lot separately.

7.3 The number of table cloth or napkins to be selected at random for inspection shall be in accordance with Table 3.

TABLE 3 SAMPLE SIZE AND PERMISSIBLE NUMBER OF NON-CONFORMING PIECES

LOT SIZE		SAMPLE SIZE	PERMISSIBLE NUMBER OF NON-CONFORMING PIECES	SUB-SAMPLE SIZE	PERMISSIBLE NUMBER OF NON-CONFORMING PIECES
(1)		(2)	(3)	(4)	(5)
Up to	50	5	0	2	0
51	150	8	0	3	0
151	300	13	1	3	0
301	500	20	1	5	0
501	1 000	32	2	8	1
1 001	3 000	50	3	8	1
3 001	and above	80	5	13	2

*Code for inland packaging of cotton cloth and yarn (*first revision*).

†Code for seaworthy packaging of cotton cloth and yarn (*third revision*).

7.4 Number of Tests and Criteria for Conformity

<i>Characteristics</i>	<i>Number of Tests</i>	<i>Criteria for Conformity</i>
Visual inspection, ends, picks, length and width	According to col 2 of Table 3	Number of non-conforming pieces not to exceed the corresponding number given in col 3 of Table 3
Dimensional change	According to col 4 of Table 3	Number of non-conforming pieces not to exceed the corresponding number given in col 5 of Table 3
Colour fastness to washing and bleaching and scouring loss	According to col 4 of Table 3	All the test specimens meet the corresponding requirement
Colour fastness to light	Two for lot size of 500 or less and 3 otherwise	All the test specimens meet the corresponding requirement

APPENDIX A*(Clause 0.4)***RECOMMENDED SI UNITS FOR TEXTILES**

<i>Sl No.</i>	<i>Characteristic</i>	<i>SI Unit</i>		<i>Application</i>
		Unit	Abbreviation	
(1)	(2)	(3)	(4)	(5)
1.	Length	Millimetre	mm	Fibres Samples, test specimens (as appropriate) Yarns, ropes, cordage, fabrics
		Millimetre, centimetre	mm, cm	
		Metre	m	

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<i>Sl No.</i>	<i>Characteristic</i>	<i>SI Unit</i>		<i>Application</i>
		Unit	Abbreviation	
(1)	(2)	(3)	(4)	(5)
2.	Width	Millimetre	mm	Narrow fabrics
		Centimetre	cm	Other fabrics
		Millimetre, centimetre	mm, cm	Samples, test specimens (as appropriate) Carpets, druggets, <i>DURRIES</i> (as appropriate)
3.	Thickness	Micrometre (micron)	μm	Delicate fabrics
		Millimetre	mm	Other fabrics, carpets, felts
4.	Linear density	Tex	tex	Yarns
		Millitex	mtex	Fibres
		Decitex	dtex	Filaments, fila- ment yarns
		Kilotex	ktex	Slivers, ropes, cordage
5.	Diameter	Micrometre (micron)	μm	Fibres
		Millimetre	mm	Yarns, ropes, cordage
6.	Circumference	Millimetre	mm	Ropes, cordage
7.	Threads in fabric			Woven fabrics (as appro- priate)
a)	Lengthwise	Number per centimetre	ends/cm	
		Number per decimetre	ends/dm	
b)	Widthwise	Number per centimetre	picks/cm	
		Number per decimetre	picks/dm	

<i>Sl No.</i>	<i>Characteristic</i>	<i>SI Unit</i>		<i>Application</i>
		Unit	Abbreviation	
(1)	(2)	(3)	(4)	(5)
8.	Warp threads in loom	Number per centimetre	ends/cm	Reeds
9.	Stitches in knitted fabric			Knitted fabrics (as appropriate)
	a) Lengthwise	Courses per centimetre	courses/cm	
		Courses per decimetre	courses/dm	
	b) Widthwise	Wales per centimetre	wales/cm	
		Wales per decimetre	wales/dm	
10.	Stitch length	Millimetre	mm	Knitted fabrics, made-up items
11.	Mass per unit area	Grams per square metre	g/m ²	Fabrics
12.	Mass per unit length	Grams per metre	g/m	Fabrics
13.	Twist	Turns per centimetre	turns/cm	Yarns, ropes, cordage (as appropriate)
		Turns per metre	turns/m	
14.	Test or gauge length	Millimetre, centimetre	mm, cm	Fibre, yarn and fabric specimens (as appropriate)
15.	Breaking load	Millinewton	mN	Fibres, delicate yarns (individual or skeins)
		Newton	N	Strong yarns (individual or skeins), ropes, cordage, fabrics

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<i>Sl No.</i>	<i>Characteristic</i>	<i>Sl Unit</i>		<i>Application</i>
		Unit	Abbreviation	
(1)	(2)	(3)	(4)	(5)
16.	Breaking length	Kilometre	km	Yarns
17.	Tenacity	Millinewton per tex	mN/tex	Fibres, yarns (individual or skeins)
18.	Twist factor or twist multiplier	Turns per centimetre \times square root of tex Turns per metre \times square root of tex	$\left. \begin{array}{l} \text{turns/cm} \\ \times \sqrt{\text{tex}} \\ \text{turns/m} \\ \times \sqrt{\text{tex}} \end{array} \right\}$	Yarns (as appropriate)
19.	Bursting strength	Newton per square centimetre	N/cm ²	Fabrics
20.	Tear strength	Millinewton, newton	mN, N	Fabrics (as appropriate)
21.	Pile height	Millimetre	mm	Carpets
22.	Pile density	Mass of pile yarn in grams per square metre per millimetre pile height	g/m ² /mm pile height	Pile carpets
23.	Elastic modulus	Millinewton per tex per unit deformation	mN/tex/unit deformation	Fibres, yarns, strands

(Continued from page 2)

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INDIAN STANDARDS

ON

HANDLOOM COTTON FABRICS

IS:

745-1975	Handloom cotton bed sheets, grey (<i>first revision</i>)
749-1978	Handloom cotton dungri cloth (<i>first revision</i>)
750-1976	Handloom cotton lungies (<i>first revision</i>)
752-1955	Handloom cotton muslin, bleached
753-1955	Handloom cotton pugri cloth, bleached or dyed
755-1955	Handloom cotton malmal, bleached
756-1955	Handloom cotton dosuti, grey, scoured, bleached or dyed
757-1971	Handloom cotton lint, absorbent, bleached (<i>first revision</i>)
758-1975	Handloom cotton gauze, absorbent (<i>second revision</i>)
854-	Handloom cotton turkish towels and towelling cloth (<i>first revision</i>)
855-1979	Handloom cotton honeycomb towels and towelling cloth (<i>first revision</i>)
856-1971	Handloom cotton huckaback towels (<i>first revision</i>)
859-1978	Handloom cotton dusters (<i>first revision</i>)
860-1956	Handloom cotton sponge cloth, grey, striped and checked
861-1956	Handloom cotton jaconet cloth, grey, dressed
862-1956	Handloom cotton ticking cloth, grey, striped
863-1969	Handloom cotton bandage cloth (<i>first revision</i>)
864-1956	Handloom cotton light sheeting, grey
1093-	Handloom cotton Madras Handkerchiefs (<i>first revision</i>).
1094-1976	Handloom cotton gada cloth (<i>first revision</i>)
1095-1957	Handloom cotton dress material, bleached, dyed, printed, striped or checked
1096-1957	Handloom cotton holland cloth, unscoured
1097-1979	Handloom cotton mosquito netting (<i>first revision</i>)
1098-1957	Handloom cotton cambric, bleached
1099-1957	Handloom cotton lining cloth, dyed
1100-1978	Handloom cotton crepe (<i>first revision</i>)
1101-1981	Handloom cotton cellular shirting (<i>first revision</i>)
1102-1968	Handloom buckram cloth (<i>first revision</i>)
1240-1958	Handloom cotton nainsook, bleached or dyed
1241-1958	Handloom cotton calico, bleached or dyed
1242-1975	Handloom cotton shirting (<i>first revision</i>)
1243-1981	Handloom cotton coating (<i>first revision</i>)
1244-1958	Handloom cotton longcloth, bleached or dyed
1245-1958	Handloom cotton pyjama cloth, grey, with stripes
1246-1978	Handloom cotton curtain cloth (<i>first revision</i>)
1247-1958	Handloom cotton Madras check
1451-1979	Handloom cotton drills (<i>first revision</i>)
1556-1960	Handloom cotton poplin, bleached or dyed
1579-1979	Handloom cotton twills (<i>first revision</i>)
1814-1961	Handloom cotton mootus, striped or checked
1937-1961	Handloom cotton bleeding Madras, loomstate
1939-1975	Handloom cotton handkerchiefs (<i>first revision</i>)
2158-1962	Handloom viscose staple fibre lungies, striped or checked
2159-1962	Handloom viscose staple fibre shirting, bleached, dyed, striped or checked
2160-1962	Handloom viscose staple fibre coating, bleached, dyed, striped or checked
2172-1962	Handloom filament rayon saris
2715-1964	Handloom cloth, collar, white
6237-1971	Handloom cotton cloth for plaster of paris bandages and cut bandages
6906-1973	Requirements for colour fastness of handloom cotton textiles
8797-1978	Handloom cotton fabric for school uniforms

INTERNATIONAL SYSTEM OF UNITS (SI UNITS)

Base Units

QUANTITY	UNIT	SYMBOL
Length	metre	m
Mass	kilogram	kg
Time	second	s
Electric current	ampere	A
Thermodynamic temperature	kelvin	K
Luminous intensity	candela	cd
Amount of substance	mole	mol

Supplementary Units

QUANTITY	UNIT	SYMBOL
Plane angle	radian	rad
Solid angle	steradian	sr

Derived Units

QUANTITY	UNIT	SYMBOL	DEFINITION
Force	newton	N	1 N = 1 kg.m/s ²
Energy	joule	J	1 J = 1 N.m
Power	watt	W	1 W = 1 J/s
Flux	weber	Wb	1 Wb = 1 V.s
Flux density	tesla	T	1 T = 1 Wb/m ²
Frequency	hertz	Hz	1 Hz = 1 c/s (s ⁻¹)
Electric conductance	siemens	S	1 S = 1 A/V
Electromotive force	volt	V	1 V = 1 W/A
Pressure, stress	pascal	Pa	1 Pa = 1 N/m ²

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'Pushpak', Nurmohamed Shaikh Marg, Khanpur
 'F' Block, Unity Bldg, Narasimharaja Square
 Gangotri Complex, Bhadhbada Road, T.T. Nagar
 22E Kalpana Area
 5-8-56C L. N. Gupta Marg
 R 14 Yudhister Marg, C Scheme
 117/418 B Sarvodaya Nagar
 Patliputra Industrial Estate
 Hantex Bldg (2nd Floor), Rly Station Road

AHMADABAD 380001 2 03 91
 BANGALORE 560002 2 76 49
 BHOPAL 462003 6 27 16
 BHUBANESHWAR 751014 5 36 27
 HYDERABAD 500001 22 10 83
 JAIPUR 302005 6 98 32
 KANPUR 208005 4 72 92
 PATNA 800013 6 28 08
 TRIVANDRUM 695001 32 27